Work Orde Friday, June 21,				*10:	Pag						
Item ID: Revision ID: Item Name:	D4034-041 Aft Upper Rib	Assembly		Accept	*N900	<u>040</u>	100	)* :	Setup Sta	· ·	S1*
	6/21/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:						
Approvals:	Process Plan:QC:		Date:			te:		I	Run Sta Sto	!/	R1*
Sequence ID/ Work Center II	— -—  — ··· )	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									<del>-</del> . <del></del> -
D4034	C										
100		Weld per dwg A/R S.	S. rod Batch: 41238	23 0.00		<del></del> ,	<del></del>		<del></del>	- <del></del> -	
*100* Large Fab Large Fab		Memo I- Assemb	le ribs to hoop and weld as p	0.00 er dwg DT9564				(	<u> </u>	- ୧୯-୦୬	9D
		2- Weld hi	ishing in rib and grind weld f	lush as per dwg							
<sup>110</sup> <b>*11∩</b> *		QC9- Inspect visual per	r QS1004- Fusion Welds	0.00	3 · 13.8.	/3		4			
QC Quality Control		Memo		0.00				- <del>-</del>		<u> </u>	1
<sup>120</sup> *12∩*		QC5- Inspect part comp	oleteness to step on W/O	o.oo	13.8.13	<b>&gt;</b>		4			
OC .		Mama		0.00	1/2012	>		_{			

Quality Control

										DQA:	Date:	
NCR:	res / No	)			WORK ORDER NON-	COI	VFORI	MANCE / UPDATE		QA Closed:	Date:	
	•		<del></del>	<del>.</del> .	DISPOSITION			AGAII	NST DE	PARTMENT		<del>"                                    </del>
Work Ord	er:				l	,			. —	7		, <del></del>
Part f	No				Rework Scrap Use-as-is	Machining Small	Small Fab Prod. Eng. Coor. Quality			Engineering Quality Other		
NCR I	No				Work Order Update	]		Large Fab Compo	site	]	Supplier	
Root				Descri	ption of work order update	T	initial	Action		Sign &	<u>-</u>	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC inspector
Doc/Data								<del></del>	-		<u></u>	
Equip/Tooling												
Operator				i								
Material			1							į		
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Other						}					l	
Process		]										
Supplier												
Training			1									
Unapproved		<u> </u>	<u> </u>	1		<u> </u>						<u> </u>
			. <u>.</u>			AUL	T CATE	GORY		<u> </u>		
Landi	ng Gear				General	_	,		r-	<b>-</b>	-	7
1	Bending Bend						Grain		_	Ovalized	<u> </u>	Pressure/Forced
	Centre	Not Conce	entric to	O/S	BOM/Route	.≱€	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Da					L	1 .	on Incomplete		Part Incorred	ļ <del>. —</del>	Weld
	Crushed/Crimped Burrs						Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	Wrong Stock Pulled
	Contamination						Mainte	nance	L	Part Moved		
	Heat Treat Countersink						Mislabe	eled		Positioned V	Vrong	

Misread Offset

Out of Calibration Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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140

QC21- Final Inspection - Work Order Release

0.00

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QC

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0.00

Quality Control

MLJ 13-08-21 MLJ 13-08-20

Insp.

Page 2

NCR:	·														
			_		<u></u>						QA Closed:	Date			
Work Orde	er:					DISPOSITION	į			AGAINST D	T DEPARTMENT/PROCESS				
Part N	•					Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite				Pro Rec/Sto	Engineering Quality Other				
NCR I	۷O	<del></del>			<del></del>	Work Order Opdate	' <u> </u>		carge rau	Composite	ا	Supplier	J LJ		
Root					Descri	ption of work order update		nitial	Act	ion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector		
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Unapproved	Щ			<u>i</u>		<del></del>	<u> </u>				<u> </u>		<u> </u>		
		···					AUL	T CATE	GORY						
Landi	_	1			_	General		la .		<u></u>	Ovalized	<del>  -</del>	Pressure/Forced		
	$\vdash$	Bending				Bend	_	Grain		- ⊢		A-1	Temperature/Cure		
		Centre No	ot Concei	ntric to	<sup>0/S</sup>  -	BOM/Route	_	Hardwa		<u> </u>	Over/Under	<del></del>	Weld		
	<b> </b>	Cracks			<u> </u>	Broken/Damaged	_	1 '	on Incomplete	<u> </u>	Part Incorred	<b>)</b> —	Wrong Stock Pulled		
	<b> -</b> -	Crushed/	Crimpea		-	Burrs	$\vdash$	Mainte	ions Incomplete/L	nciear	Part Lost/Mi	rssing	TANIOUR STOCK LINEO		
	⊢	Cuffs	- <b>4</b> -		<u> </u>	Contamination	<u> </u>	Mislabe		<u> </u>	Positioned V	Vrong			
	Heat Treat					Countersink	$\vdash$	1		<u> </u>	Power Loss/	_	Other		
	Inspection Strip in Tube					Cut Too Short Misread					Trower ross/	Jui 8c	Toulei		
	$\vdash$	Ripples in		*	_	Drill Holes	OffsetOut of Calibration								
	<u> </u>	Torque W			"	Drawing	H	4					<del></del>		
ì	Turning Sequence   Finish   Out of Sequence							sequence							

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Folio

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Picklist Print Friday, June 21, 20.												1	Page /
Work Order ID: 10	3356		*	10335	6*							- <del></del>	<u>-</u>
Parent Item: Da	4034-041				 4-041*								
Parent Item Name:	mbly							tart Date: 6/ Start Qty: 4.		Required Date: 7/5/2013 Required Qty: 4.00			
Comments:	IPP RevA: new issu per dwg revA 10.00 DWG REV.B DD REV.pc1 DD VE VERF:JFS	3.15 verified by:E VERF:EC	C IPP Re	IPP Re v:D 13.03.14	IPP Rev v:C 11.01.19 / F AS PER DWC G REV.C DD	AS PER							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per K	t Total Qty	Qty Issaad	Date Sta	atus
D4034-I		Manufactured	No			100	Each	11.0000	1	4			
*D4034-1	1*								**			<del></del> 4v_	
				<u>Location</u> WA004	<u>n</u>	Loc	<u>Oty</u> 11	Loc Code		~	de 12	3 -08 -09	5
					101056		8				_		
					83 <b>7</b> 55 89359		1				_		
					97591		i				<del></del>		
D4034-3		Manufactured	No			100	Each	14.0000	I	4	_ ,		
*D4034-3	<b>3</b> *								** /	B 101	01 <u>3</u>	-2x 1	Y_18
				Location	<u>1</u>	Loc	<u>Otv</u>	Loc Code	_	B 1033	360 <del>-&gt;</del>	<i>-</i> ک∠	
				WA			Q				1		

101013

101014

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WA004

WA005

											DQA:	Dat	e:		
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											QA Closed:	Dat	e:		
Work Orde	or.					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
WOIK OIG	-''-		-			Rework			Skid-tube Crosstube			Water Jet	Enginee	ring	
Part N	lo.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Qui	ality		
						Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging		ther	
NCR N	lo					Work Order Update	Large Fab Composite Supplier							Ш	
Root	T				Descri	ption of work order update		nitial	Act	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Ins	spector	
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Equip/Tooling								:							
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Supplier	$\square$										ĺ				
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						Fi	AUL	T CATE	GORY				<u>.</u>		
Landi	ng G	ear	-			General				_	<b>-</b>	-	<del>,</del>		
-		Bending				Bend		Grain		L	Ovalized	1	Pressure/F		
	Centre Not Concentric to O/S BOM/Route							Hardwa	re	L	Over/Under	tolerance	Temperatu	ıre/Cure	
	Cracks Broken/Damaged						L	Inspecti	on incomplete	<u></u>	Part Incorred	it [	Weld		
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Sto	ck Pulled	
Cuffs						Contamination		Mainte	nance		Part Moved				
	Heat Treat Countersink							Mislabe	led	[	Positioned V	_			
	$\square$	nspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes							Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print						Page 2
Friday, June 21, 2013 3:01:12	PM					
Work Order ID: 103356		*103356*	<del></del>	<del>-</del> <del>-</del> -	· <del></del> ·	
Parent Item: D4034-041		*D4034-041	*			
Parent Item Name: Aft Upper F	Rib Assembly	1 14(1.54-(14 )			: 6/21/2013	Required Date: 7/5/2013
				Start Qty	: 4.00	Required Qty: 4.00
D4021-7	Manufactured	No	100 Each	8.0000 1	4	
*D4021-7*				**	B103	S82 - 44 SH 13.08.05
		Location	Loc Qty	Loc Code		SH 13.00 ==
		WA004	8			
		100432	5			<u> </u>
		88428	3			<u> </u>
D4021-9	Manufactured	No	100 Each	261.0000 4	16	
*D4021-9*				**		3746-> 12x_
		Location	Loc Oty	Loc Code	B+o.	2204 -> 4x
		WA002	6			2664 W
		102482	4			13 08 05
		99143	2			_
		WA004	255			
		100402	75			<u> </u>
		100917	40			
		102664 66437	80			<del></del> ;
		70333	2			<del></del>
		72482	4		<del></del>	
		82977	1			<del></del>
		84717	3			<u> </u>
		88077	23			
		88377	7			1
		กวกาก	12			

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	_											QA Closed:	Da	ite:	<del></del>
Work Orde	. p.					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No.						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing					Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
NCR N	lo	<del></del>				Work Order Update			Large Fab	Composite			Supplier		
Root					1	ption of work order update		nitial		tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	4	Date	Verificatio	n_	QC Inspector
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						F	<u> </u>	T CATE	GORY						
Landi	ng Ge	ear				General	_			_	_	ı			•
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		╝	Over/Under	tolerance		Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete	_		Part Incorred	:t	$oxed{\!$	Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	<b>—</b> — —					Contamination		Mainte	nance			Part Moved			
	Heat Treat Countersink					Countersink		Mislabeled				Positioned Wrong			_
	$\prod_i$	Inspection Strip in Tube Cut Too Short						Misread	I	Power Loss/Surge				Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

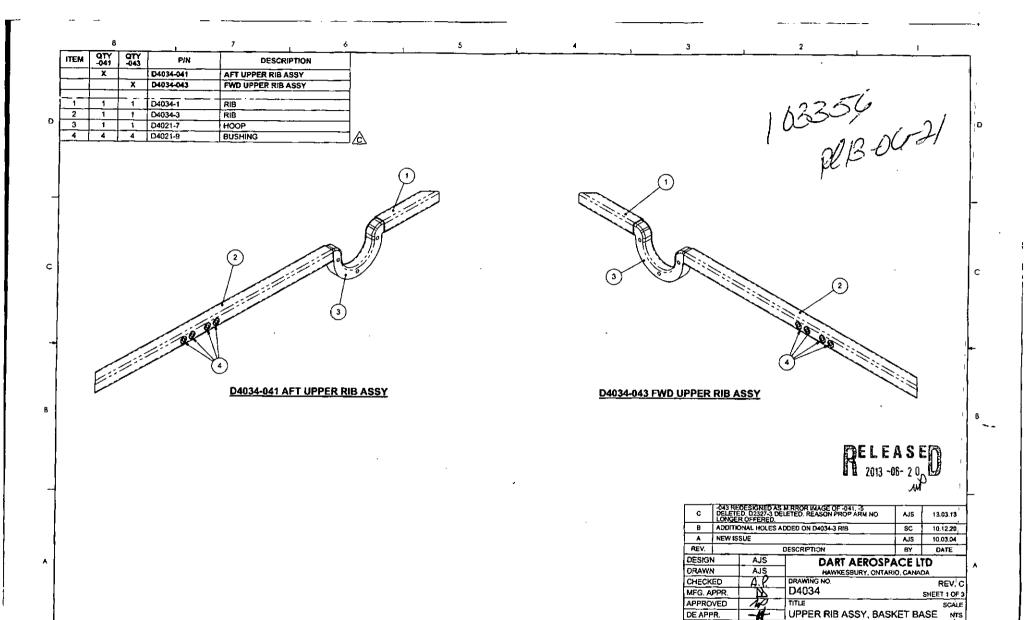
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



DATE

13.03.13

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-	100	VFOR	MANCE / UP	DATE	QA Closed:	 Date:	
Work Orde	er:	·	<del></del>		er <sup>e</sup> s.	DISPOSITION		_		AGAINST DE			
Part No.  NCR No.					,	Scrap Machining Small Fa Use-as-is Thermoforming Finishin				Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Desc	ription of work order update	Ī	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		•				<b>;</b>						·	
							FAU	LT CATE	GORY				<u> </u>
Landi	ng G	iear				General		_	<del>-</del> .		_		1
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Lut Too Short Drill Holes		-1 `	ion Incomplete ions Incomplete/ enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	$ldsymbol{\sqcup}$	inhhies ii	· DCIIG	•	. ~ -			4					

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio